Tuesday, 12/18/2007 10:46:01 AM

Uper:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 36399

: 11071

P.O. Number This Issue

Prsht Rev.

First Issue

Previous Run

: 12/18/2007

: NC

: 17 : 29869

S.O. No. :

: MACHINED PARTS Type

Part Number

Drawing Name

Drawing Number Project Number

D2957 REV B : N/A

: D2957

Drawing Revision

: B

Material

Due Date

: 1/5/2008

: MOUNTING PLATE

Qty:

Each

Checked & Approved By

Comment

Written By

: Est:

00.08.09

New dwg rev B (mpp 2078)EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6B0500X01250

6061-T6 Bar .50" x 1.25"

6061-T6 Bar .50" x 1.25"

Comment: Qty.:

0.1838 f(s)/Unit

Material: 6061-T6 bar 1.25" x 0.50"

Total:

3.6750 f(s)

2.0

1111111

BAND SAW

BAND SAW

Comment: BAND SAW

Cut blanks 10.500" long

1 blank makes 5 parts

HAAS CNC VERTICAL MACHINING #1

3.0

HAAS1

Comment: HAAS CNC VERTICAL MACHINING #1

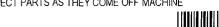
Machine as per folio FA042

Tumble & Deburr

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

.5.0

QC8

SECOND CHECK

Comment: SECOND

\$6

19

6.0

QC5

INSPECT WORK TO CURRENT STEP





Comment: INSPECT WORK TO CURRENT STEP

19

Dart Aerospace Ltd

W/O:		WORK ORDER CH					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·						

Part No: D2957 PAR #: MA Fault Category: Part Mouh; and Part NCR: (es) No DQA: Date: 8/0/14

QA: N/C Closed: Date: 08 02 14

NCR: 3	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
poloolos	3	piece scrip too thin \$.025" the face mill grate the piece	Bar	Scrap and replace Batch: 7872	ml 08/02/08	oslali6	B 2712	colalo	
				-					
					,				

NOTE: Date & initial all entries

Tuesday, 12/18/2007 10:46:01 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: MOUNTING PLATE Customer: CU-DAR001 Dart Helicopters Services Job Number: 36399 Part Number: D2957 Job Number: Description: Seq: #: Machine Or Operation: PACKAGING RESOURCE #1 PACKAGING 1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Ae	rospace l	Ltd							
W/O:		:	WC	ORK ORDER CHANGES		-			
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
,									
Part No	:	PAR #:	Fault Cate	gory: N	CR: Yes	No DQ	A:	_ Date: _	
					QA: N	/C Close	d:	Date:	
NCR:			WORK ORDI	ER NON-CONFORMANC	E (NCR)			
DATE	Description of NC		Corrective Action Section B			Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
							!		
		*							
									}

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36399
Description: Mounting Plate	Part Number:	D2957
Inspection Dwg: D2957 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	+/-0.030	0.25b				
0.068	+/-0.010	0.069	\			
Ø0.323	+/-0.010	Ø0.325	/			
0.250	+/-0.010	0.247				
1.06	+/-0.030	1.066				
0.875	+/-0.010	.873				
0.449	+/-0.010	0.450				
R0.12	+/-0.030	R. 125				
1.85	+/-0.030	1.855				
0.250	+/-0.010	0.244				·
0.19	+/-0.030	0, 190				
0.125	+/-0.010	0.125				
						·

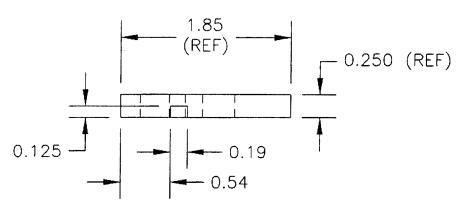
Measured by:	Inf	Audited by:	-51	Prototype Approval:	N/A
Date:	08/02/08	Date:	08-02-08	Date:	N/A

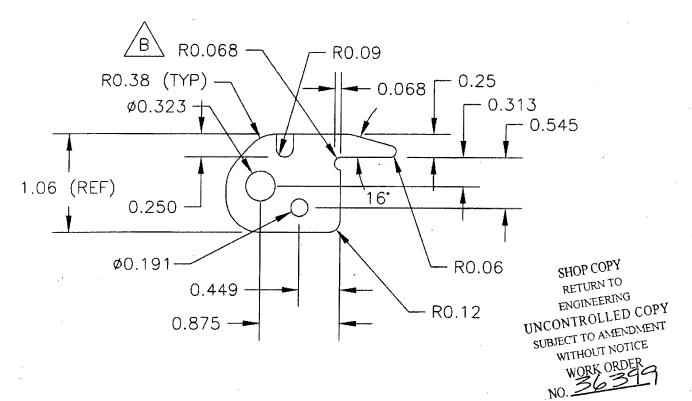
Rev	Date	Change	Revised₁by	Approved
Α	04.04.20	New Issue	KJ/RF	<u> </u>



DESIG	N RF	DRAWN BY	DART AEROSPACE LTD
	KT	PF	HAWKESBURY, ONTARIO, CANADA
CHEC	KEOM	APPROVED	DRAWING NO. REV. B
	\mathcal{M}	#\	D2957 SHEET 1 OF 1
DATE			TITLE SCALE
00.0	07.06		MOUNTING PLATE 1:1
Α		00.01.20	NEW ISSUE
В		00.07.06	MODIFY CORNER DETAIL

RELEASED (ao. 07.18 4)





MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11) 0.250 THICK .

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED BREAK ALL SHARP EDGES 0.010 TO 0.020

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